

Date: Monday, 23/02/2009 10:09:36 AM
 User: Julie Dawson

Process Sheet

| | |
|---|--|
| Customer : CU-DAR001 Dart Helicopters Services | Drawing Name : RIB/ GUSSET ASSY |
| Job Number : 45943 | |
| Estimate Number : 13651 | |
| P.O. Number : | Part Number : D3826041 |
| This Issue : 23/02/2009 S.O. No. : | Drawing Number : D3826 REV A |
| Prsht Rev. : NC | Project Number : N/A |
| First Issue : / / Type : LARGE FAB ASSY | Drawing Revision : A |
| Previous Run : 45506 | Material : |
| Written By : | Due Date : 27/02/2009 Qty: 4 Um: Each |
| Checked & Approved By : <u>JUD 09-02-23</u> | |
| Comment : Est Rev:A 08-12-01 new issue DD verified by:EC | |

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

D22351

Basket Rib



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Basket Rib

batch: 345939

PD 09-02-24

2.0

D2325

Support Gusset (350 Basket)



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Support Gusset (350 Basket)

batch: 643289

PD 09-02-24

3.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1- use DT9434 to assemble D2325 support gusset together

2- locate D2325 on rib and weld as per dwg D3826

A/R ER316 S.S. Rod Batch: M107051

PD 09-02-24

4.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

CP 09-02-24

5.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 02/02/24 @

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Monday, 23/02/2009 10:09:36 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: RIB/ GUSSET ASSY

Job Number: 45943

Part Number: D3826041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *Basket*

PD 09-02-24

7.0

QC21

FINAL INSPECTION/W/O RELEASE



09/02/25

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MR 09-02-24

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

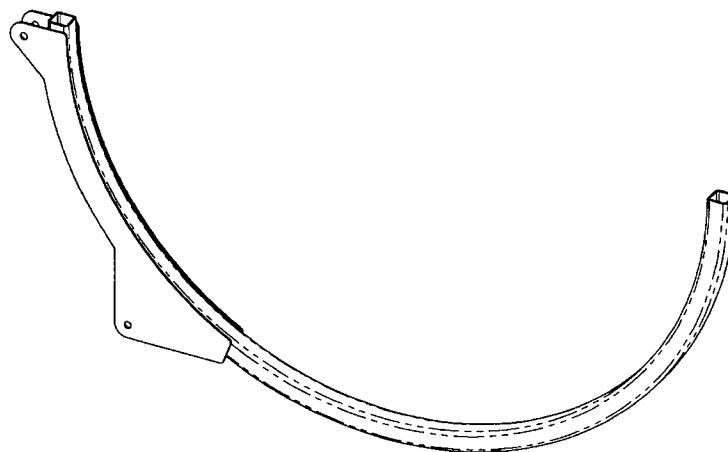
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

| ITEM | QTY -041 | P/N | DESCRIPTION |
|------|-------------|-----------|---------------------|
| 1 | X | D3826-041 | RIB/GUSSET ASSEMBLY |
| 2 | 1 | D2235-1 | RIB |
| 3 | 2 | D2325 | SUPPORT GUSSET |



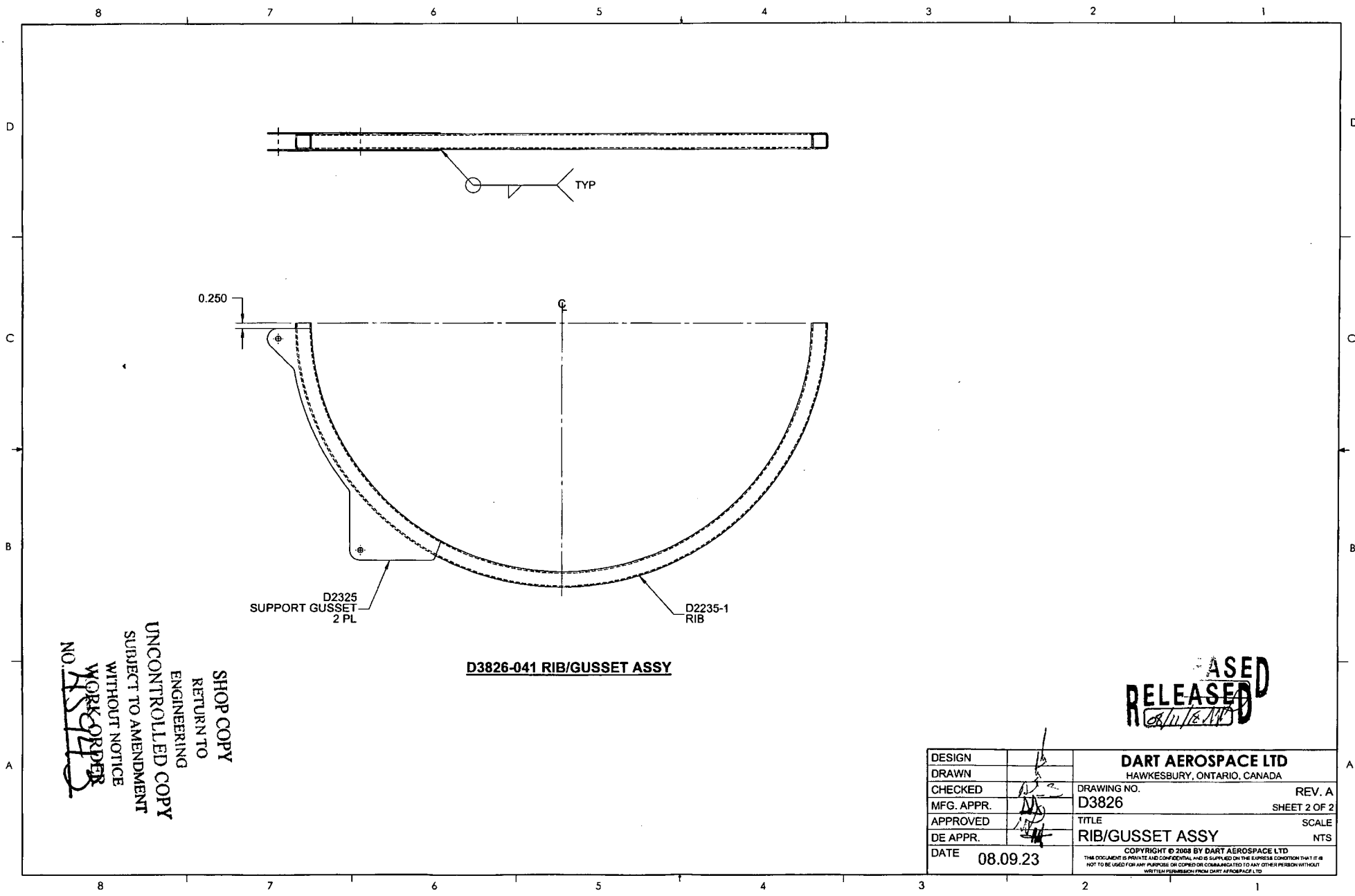
D3826-041 RIB/GUSSET ASSY

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
NO. 24843

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 2.59 lbs

RELEASED
08/11/19

| | | | |
|------------|-------------|---|--------------|
| A | NEW ISSUE | MB | 08.09.23 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | | DRAWING NO. | REV. A |
| CHECKED | | D3826 | SHEET 1 OF 2 |
| MFG. APPR. | | TITLE | SCALE |
| APPROVED | | RIB/GUSSET ASSY | NTS |
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| DATE | 08.09.23 | | |



D3826-041 RIB/GUSSET ASSY

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 WORK ORDER
 NO. **15943**

RELEASED
 8/11/18 MP

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|------------|-----------------|--|--------|
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| DRAWN | | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | | DRAWING NO. D3826 | REV. A |
| MFG. APPR. | | SHEET 2 OF 2 | |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | RIB/GUSSET ASSY | NTS |
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